

541744 DREV

Work Order ID 54190

December 2, 2009 11:40:09 AM



Page 1

Item ID: D3438-042

Accept



Setup Start



Revision ID: A

Stop



Item Name: Step Weldment Assembly

Start Date: 02/12/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 09/12/2009 Req'd Qty: 2.00



Customer:

Reference:

Run Start

Approvals: Process Plan: *PL*

Date: 09-12-2

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3438

Rev A

100



Large Fab

0.00

Large Fab

Memo

0.00

Large Fab

1-Cut D2244 to .79.63" at 34° as per Dwg D3438 2-Deburr ends 3-Weld one cap, LUG PLATES & MOUNTING ANGLE as per Dwg D3438 using DT8343

4

4-Grind *PL*

110



QC9- Inspect visual per QSI004- Fusion Welds

0.00

QC

Memo

0.00

Quality Control

120



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

2) 8 or 12 108

2 *PL*

D 09.12.08 (2)

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item Name:	Step Weldment Assembly					
Start Date:	02/12/2009	Start Qty:	2.00	Cust Item ID:		
Required Date:	09/12/2009	Req'd Qty:	2.00	Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00	H 09.12.14			2	0		
140 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	SN 09/12/14			2	0		
150 Large Fab Large Fab	Large Fab Memo Weld last cap per dwg D3438 & grind flush	0.00 0.00	H 09.12.14			2	0		

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Item ID: D3438-042 Accept  Setup Start 
Revision ID: A Stop 
Item Name: Step Weldment Assembly
Start Date: 02/12/2009 Start Qty: 2.00  Cust Item ID:
Required Date: 09/12/2009 Req'd Qty: 2.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190



HandFinish

Hand Finishing

HandFinishing

Memo

Wing Walk as per Dwg 3438 and QSI 005 4.4 Mask off 0.5 each side of D2561
lugs

M112623

0.00

0.00

= 7 M 09-12-16

200



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

210



Packaging

Packaging

Identify as per dwg & Stock Location: _____

Memo

PPD

54191

0.00

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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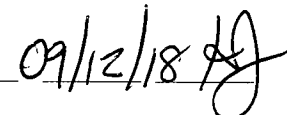


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Item Name: Step Weldment Assembly
Start Date: 02/12/2009 Start Qty: 2.00  Cust Item ID:
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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	QC21- Final Inspection - Work Order Release	0.00							
 QC	Memo	0.00							
Quality Control									

09/12/18 PL 09-12-18
(2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 54190

Parent Item: D3438-042RevA

Parent Item Name: Step Weldment Assembly

Start Date: 02/12/2009

Required Date: 09/12/2009

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2244-116RevD1		Manufactured	No			100	Each	39.0000	2.0000			



Step Extrusion

209.11.07

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

39

38023

39

D2561RevB

Manufactured

No

100

Each

45.0000

4.0000



Lug

2
209.11.07

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

45

53616

45

D2673-34RevB

Manufactured

No

100

Each

2.0000

4.0000



End Plate

4
209.11.07

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

2

36406

2

4

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Parent Item Name: Step Weldment Assembly



Start Date: 02/12/2009

Required Date: 09/12/2009

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2564RevB1		Manufactured	No			110	Each	35.0000	4.0000			
											<u>09.12.07</u>	
Mounting Angle												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

35

47966

35

4

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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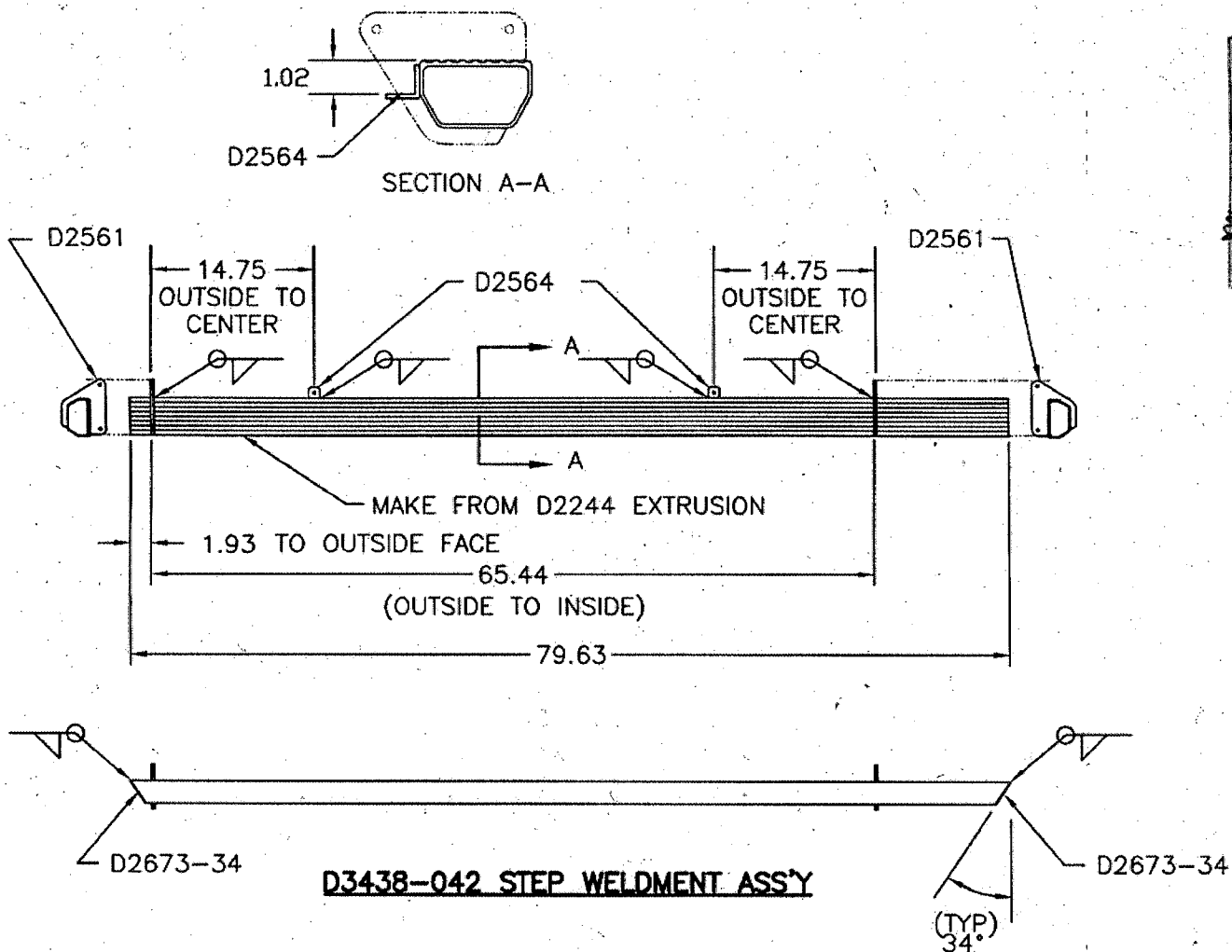
NOTE: Date & initial all entries

DART

RELEASED

05.05.09

DESIGN	RF	DRAWN BY	RF	DART AEROSPACE LTD
CHECKED		APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	05.05.09			D3438
				STEP WELDMENT ASSEMBLY
				NEW ISSUE
				REV. A
				SHEET 1 OF 1
				SCALE 1:1



NOTES:

- 1) WELD PER DART QSI 004
- 2) TOLERANCES ARE PER DART QSI 018
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) FINISH: ACID ETCH & ALODINE PER QSI 005 4.1, POWDER COAT WHITE PER QSI 005 4.3.5.1
WING WALK TOP PER QSI 005 4.4, MASK OFF 0.5 EACH SIDE OF D2561 LUGS